



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D505-1049-011
Job Sheet 174368-A



Part No: D505-1049-011

Job Qty: 1 ea

Part Name: 505 Bearpaws with wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: Dwg. D505-1049 Rev.B IPP Rev.A New issue JFS 17/11/01 Verified by:DD IPP Rev.B Updated Bom per dwg.
RevB JFS 18/03/01 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	4/13/18	4/13/18	0.00	0.00	Start Up Stores/Pkg-2			APR 12 2018
160	Packaging	1 pcs	4/13/18	4/13/18	0.00	0.00	Packaging1			APR 12 2018
170	QC	1 pcs	4/13/18	4/13/18	0.00	0.00	QC4			Smb
175	DC	1 pcs	4/13/18	4/13/18	0.00	0.00	DC			Smb
180	Packaging	1 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3			Smb
190	QC21-FG	1 Ea	4/13/18	4/13/18	0.00	0.00	QC21			21 APR 13 2018

Part Op 175 - Photocopy bluefile and create labels per PPP D505-1049-011 CHG001
Descriptions: 180 - Identify and pack for shipping as per PPP d505-1049-011 LOCATION:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2274	Radius Block	8 Ea (8 ea)	90-Start up Operation	5031567
D2529	Washer	16 Ea (16 ea)	90-Start up Operation	5019348
D5560-1	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5051783
D5566-1	Clamp	4 Ea (4 ea)	90-Start up Operation	5051685
MS21042L4	Nut	8 Ea (8 ea)	90-Start up Operation	5045901
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5045845
NAS1801-4-30	Bolt	8 pcs (8 ea)	90-Start up Operation	5021412
QS200-M40S	Clamp	2 pcs (2 ea)	90-Start up Operation	5058465
D5567-1	Cushion	4 Ea (4 ea)	160-Packaging	5060110
MS21083N4	Nut	8 Ea (8 ea)	160-Packaging	5041747

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2274	8	216	0
	D2529	16	2,370	0
	D5560-1	2	7	0
	D5566-1	4	44	0
	MS21042L4	8	3,411	0
	NAS1149D0463J	8	5,191	0
	NAS1801-4-30	8	36	0
	QS200-M40S	2	19	0
160-Packaging	D5567-1	4	34	0
	MS21083N4	8	40	0
Part Specifications				
Specifications could not be found.				

Plex 4/12/18 12:32 PM dart.lacelle.linda

D505-1049-011
 505
 Bearpaws
 with
 wearplates
 Active
 Job No : 174368 *A*
 Operation : 90-Start up Operation
 Next Op : 160-Packaging
 Description:
 Status : Allocated
 Change
 Number :
 Printed : 4/12/18 12:32 PM Linda Lacelle
 Special
 Comments :



Allocated

Container No : **S060436** Dart Hawkesbury

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D505-1049-011
Job Sheet 174368



002432

Part No: D505-1049-011

Job Qty: 4 ea

Part Name: 505 Bearpaws with wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/14/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg. D505-1049 Rev.B IPP Rev.A New Issue JFS 17/11/01 Verified by:DD IPP Rev.B Updated Bom per dwg.
RevB JFS 18/03/01 Verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/13/18	0.00	0.00	Start Up Stores/Pkg-2		
160	Packaging	4 pcs		4/13/18	0.00	0.00	Packaging1		
170	QC	4 pcs		4/13/18	0.00	0.00	QC4		
175	DC	4 pcs		4/13/18	0.00	0.00	DC		
180	Packaging	4 pcs		4/13/18	0.00	0.00	Packaging3		
190	QC21-FG	4 Ea		4/13/18	0.00	0.00	QC21		

Part Op 175 - Photocopy bluefile and create labels per PPP D505-1049-011 UHG001
Descriptions: 180 - Identify and pack for shipping as per PPP d505-1049-011 LOCATION:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2274	Radius Block	32 Ea (8 ea)	90-Start up Operation	5054567
D2529	Washer	64 Ea (16 ea)	90-Start up Operation	5019348
D5560-1	Bearpaw	8 Ea (2 ea)	90-Start up Operation	5051783
D5566-1	Clamp	16 Ea (4 ea)	90-Start up Operation	5051685 x 1.5
D5567-1	Cushion	16 Ea (4 ea)	90-Start up Operation	
MS21042L4	Nut	32 Ea (8 ea)	90-Start up Operation	5045901
MS21083N4	Nut	32 Ea (8 ea)	90-Start up Operation	
NAS1149D0463J	Washer	32 Ea (8 ea)	90-Start up Operation	5045845
NAS1801-4-30	Bolt	32 pcs (8 ea)	90-Start up Operation	5021412
QS200-M40S	Clamp	8 pcs (2 ea)	90-Start up Operation	5058465

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

505
Bearpaws
with
wearplates
Active

Job No :

17436

D505-1049-011

Operation : 90-Start up Operation

Next Op : 180-Packaging

Description :

Status : Allocated

Change

Number :

Printed :

Special

Comments :

Quantity : 4

Heat Code :

4/12/18 11:56 AM Linda Lacelle



4/12/18 11:56 AM Linda Lacelle

Container No : **S060435** Dart Hawkesbury

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2274	32	292	0
	D2529	64	2,470	0
	D5560-1	8	15	0
	D5566-1	16	16	0
	D5567-1	16	2	0
	MS21042L4	32	3,591	0
	MS21083N4	32	130	0
	NAS1149D0463J	32	5,519	0
	NAS1801-4-30	32	68	0
	QS200-M40S	8	27	0

Part Specifications

Specifications could not be found.

Plex 4/10/18 2:28 PM dart.quirion.sonia

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002432	S060251	D2274	Radius Block	S054567	ST006	32
002432	S060247	D2529	Washer	S019348	ST008	64
002432	S060237	D5560-1	Bearpaw	s051783	ST445	8
002432	S001779	D5566-1	Clamp	FM137764	ST545	1
002432	S051685	D5566-1	Clamp	S051684	ST545	15
002432	S060212	MS21042L4	Nut	S045901	ST303	32
002432	S060170	NAS1149D0463J	Washer	s045845	ST263	32
002432	S060164	NAS1801-4-30	Bolt	S021412	ST548	32
002432	S060162	QS200-M40S	Clamp	S058465	ST546A	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/12/18 8:26 AM dart.quirion,sonia

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D505-1049-011	11.1 lb	0.0 in	0.0 in-lb	191.6 in	2127 in-lb
<i>Bearpaw Installation</i>	5.03 kg	0.0 m	0.0 m-kg	4.87 m	24.5 m-kg
D505-1049-013	14.5 lb	0.0 in	0.0 in-lb	191.4 in	2775 in-lb
<i>Bearpaw Installation with Wearplates</i>	6.58 kg	0.0 m	0.0 m-kg	4.86 m	32.0 m-kg
D505-1049-041	3.4 lb	0.0 in	0.0 in-lb	190.8 in	649 in-lb
<i>Wearplate Kit</i>	1.54 kg	0.0 m	0.0 m-kg	4.85 m	7.5 m-kg

5 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D505-1049-011	BEARPAW INSTALLATION
	X		D505-1049-013	BEARPAW INSTALLATION WITH WEARPLATES
		X	D505-1049-041	WEARPLATE KIT
8	8		D2274	Radius Block
16	16	8	D2529	Washer
4	4		D5566-1	Clamp
4	4		D5567-1	Cushion
	2	2	D5559-041	Wearplate
2	2		D5560-1	Bearpaw
	8	8	AN4-7A	Bolt
8	8		NAS1801-4-30	Bolt
8	8		NAS1149D0463J	Washer
8	16	8	MS21042L4	Nut (or MS21042-4)
8	8		MS21083N4	Nut
2	2		QS200-M40S	Hose Clamp

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Revision: **B**

Date: 18.02.01